



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2893-1
Job Sheet 210713



Part No: D2893-1

Job Qty: 12 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/19/20

Job Tracking No:

Due Date: 6/30/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG D2893 REV D IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E
Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15
add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C verf:ECDWG /IPP Rev. I 19.10.01 New
issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	12 pcs	6/29/20		2.00	30.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	12 pcs	6/29/20		0.00	0.00	QC 8 - 12		OK 20/07/06 MJP
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		DAS 52 9-89 20/07/06
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



Container No: S286251



Part: D2893-1

Job No: 210713

Serial No/Batch: S286251

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/06/20

					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130	Crosstubes - 2 - B4B	12 pcs	6/30/20	0.00 2.00	Crosstubes - 1 - B4B	DAS
					Crosstubes - 2 - B4B	87 JUL 09 2020
					Crosstubes - 3 - B4B	9-29
					Crosstubes - 4 - B4B	
140	QC 3	12 pcs	6/30/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	DAS
					QC 3 - 61	32
					QC 3 - 81	9-89
					QC 3 - 82	JUL 10 2020
					QC 3 - 87	
170	Packaging 3-1 - Stock - B4B	12 pcs	6/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC LG 050
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	JUL 10 2020

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180	QC 21 - SA	12 pcs	6/30/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					Broussard
					QC 21 - SA - 9
					QC 21 - SA - 77

DAS
21 JUL 10 2020
89

Part Op **100** - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and use DT10660 apply 3M Scotch-Weld as per dwg. **S 206499**
140 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	6 pcs (.5 ea)	100-HAAS 4 Axis	S 257569 X1
				S 244325 X2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	6	3	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

Plex 6/19/20 7:39 AM dart.lacelle.linda

DART AEROSPACE LTD		Work Order: 210713
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.125	0.160		.145	.140	.145	.145	.142
AB	0.040	0.060		.050	.051	.050	.050	.050
AC	Ø0.260	Ø0.266		.263	.263	.263	.263	.263
AD	Ø0.187	Ø0.193		.188	.188	.188	.188	.188
AE	0.240	0.250		.250	.250	.250	.250	.250
AF	1.347	1.407		1.367	1.372	1.369	1.369	1.372
AG	1.200	1.240		1.207	1.207	1.208	1.208	1.205
AH	0.147	0.167		.161	.161	.156	.156	.164
AI	2.985	3.005		3.000	3.000	2.990	2.990	3.002
AJ	0.400	0.500		.460	.460	.460	.460	.460
AK	4.930	4.990		4.959	4.959	4.952	4.952	4.958
AL	0.125	0.160		.137	.137	.137	.137	.137
AM	R0.053	R0.073		.063	.063	.063	.063	.063
AN	R0.240	R0.260		.250	.250	.250	.250	.250
AO	R0.021	R0.041		.031	.031	.031	.031	.031
AP	0.150	0.180		.175	.173	.175	.175	.171
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	2.302	2.322		2.317	2.317	2.315	2.314	2.321
AS	0.140	0.160		.151	.152	.152	.151	
AT	0.040	0.060		.051	.047	.049	.052	.048
Accept/Reject				✓	✓	✓	✓	✓

Measured by: DAK / M.P. Date: 20/06/30

Audited by: 52 Date: 20/07/06
9-89

Preliminary Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	
E	20.02.10	Dwg Rev and Dimensions updated.	MG <i>mg</i>	DP

DART AEROSPACE LTD		Work Order: 210713
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	2	3	4	5
HAAS Section								
AA	0.125	0.160		.146				
AB	0.040	0.060		.050				
AC	Ø0.260	Ø0.266		.263				
AD	Ø0.187	Ø0.143		.188				
AE	0.240	0.250		.250				
AF	1.347	1.407		1.371				
AG	1.200	1.240		1.208				
AH	0.147	0.167		.159				
AI	2.985	3.005		3.003				
AJ	0.400	0.500		.460				
AK	4.930	4.990		4.958				
AL	0.125	0.160		.137				
AM	R0.053	R0.073		.063				
AN	R0.240	R0.260		.250				
AO	R0.021	R0.041		.031				
AP	0.150	0.180		.175				
AQ	0.053	0.073		.063				
AR	2.302	2.322		2.321				
AS	0.140	0.160		.154				
AT	0.040	0.060		.051				
Accept/Reject								

Measured by: <i>[Signature]</i>	Date: 20/07/06
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Audited by: 52	Date: 20/07/06
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